 RED BARN MACHINE			
TITLE KSTER## SERIES SWAGING TOOL; LOCATING PIN			
DWG NO. TOOL# (see chart)-15			REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± .5°		DRAWN BY: PERRITT APPROVED _____ HEAT TREAT _____ FINISH SPEC BLACK OXIDE _____ USED ON BEARING SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS AFTER PLATING			
SCALE NTS	DATE 8-14-08	SHEET 9 of 9	



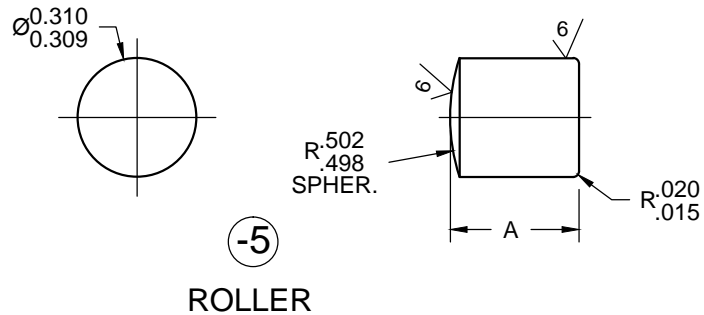
DWG NO.	TOOL# (see chart)-9	REV 1
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UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON BEARING
	SEE Pg. 1

SCALE	NTS	DATE	8-14-08	SHEET	6 of 9
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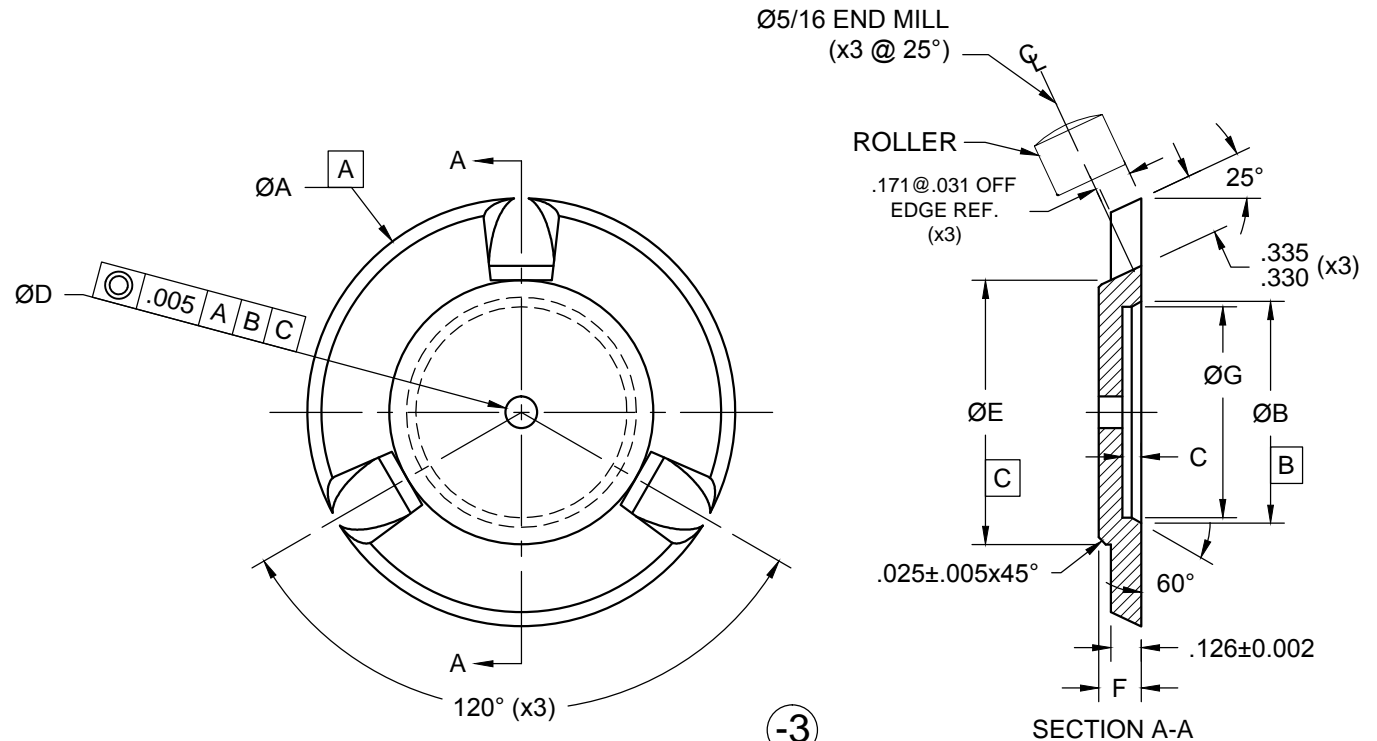
NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).



TOOL #	A +.001 -.001	MATERIAL
KSTER04	.335	.310 MINUS GAUGE PIN MSC#89031009
KSTER05	.335	.310 MINUS GAUGE PIN MSC#89031009

RED BARN MACHINE			
TITLE KSTER## SERIES SWAGING TOOL; ROLLER (QTY. 3)			
DWG NO. TOOL# (see chart)-5			REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° X ± .1		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE Pg. 1	
SCALE NTS	DATE 8-14-08	SHEET 4 of 9	



RETAINER

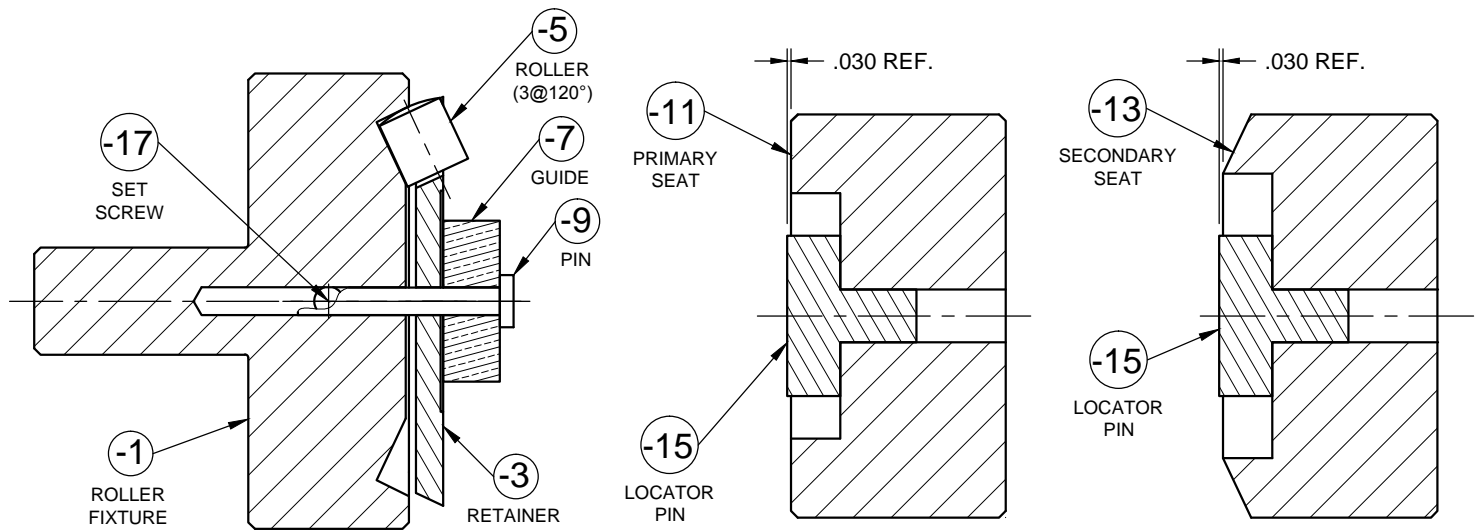
NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

TOOL #	ØA +.002 -.002	ØB +.010 -.005	C +.020 -.000	ØD +.004 -.001	ØE +.000 -.015	F +.010 -.010	ØG +.010 -.005	P.D. REF.	MATERIAL
KSTER04	1.258	.402	.030	.136	0	0	.402	.680	BRONZE RND. BAR Ø1-3/8 x 1/4
KSTER05	1.321	.499	.030	.136	0	0	.465	.743	BRONZE RND. BAR Ø1-3/8 x 1/4

RED BARN MACHINE			
TITLE KSTER## SERIES SWAGING TOOL; RETAINER			
DWG NO. TOOL# (see chart)-3			REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1		FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC	
SCALE NTS		USED ON BEARING SEE Pg. 1	
DATE 8-14-08		SHEET 3 of 9	

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED TOOL ER04.	1/9/09	WP	-



NOTES

1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.
4. ENGRAVE AS SHOWN WITH "KST" & BEARING No.

BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
BACB10ER04	KSTER04
BACB10ER05	KSTER05

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		-13	SEE CHART	SECONDARY SEAT	SEE CHART	8
		-15	SEE CHART	LOCATING PIN	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

RED BARN MACHINE

TITLE

KSTER## SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10ER## BEARINGS

DWG NO.

TOOL# (see chart above); ASSEMBLY

REV

1

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCES ON:
DECIMALS
.XXX ± .005
.XX ± .01
.X ± .1

FRACTIONS ± 1/32
ANGLES ± 5°

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

SCALE

NTS

DATE

8-14-08

SHEET

1 of 9

DRAWN BY:

PERRITT

APPROVED


HEAT TREAT LISTED PER ITEM

FINISH LISTED PER ITEM

SPEC USED ON BEARING

SEE ABOVE

[illegible]

 RED BARN MACHINE	
TITLE --	
DWG NO. --	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE NTS	DATE 8-15-07
SHEET 1 of 1	

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--

DRAWN BY: PERRITT	<div>RB</div> RED BARN MACHINE		
CHECKED	TITLE		
HEAT TREAT FINISH SPEC	TITLE		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	FRACTIONS ± 1/32 ANGLES ±.5°		REV.
USED ON MODEL ?	DWG NO. PART #		
	SCALE NTS	DATE 1-28-06	SHEET 1 of 1
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		

[illegible]

ED

REV		DESCRIPTION	DATE	APPROVED

Technical drawing of a lathe tool rest assembly, showing multiple views and dimensions. The drawing includes a large diagonal watermark reading "NOT APPROVED FOR PRODUCTION".

Views and Dimensions:

- PRIMARY (11):** Shows a cross-section with a P.F. Ø.246 PN:-15 and a .995 dimension.
- SECTION A-A:** Shows a cross-section with a .228 dimension and a .995 dimension.
- SECONDARY (13):** Shows a cross-section with a P.F. Ø.246 PN:-15 and a .995 dimension.
- SECTION A-A:** Shows a cross-section with a .995 dimension and a .864 dimension.
- HEAT TREAT BASE (1):** Shows a cross-section with a .150±.002 dimension and a .016 dimension.
- BRASS SPACER (7):** Shows a cross-section with a .242±.002 dimension and a .0130 dimension.
- HEAT TREAT RC 55-60 (15):** Shows a cross-section with a .093 dimension and a .100 dimension.
- SECTION A-A:** Shows a cross-section with a .365 (x3) dimension and a .012±.001 dimension.
- BRASS GUIDE (3):** Shows a cross-section with a .126 dimension and a .125 dimension.
- SECTION A-A:** Shows a cross-section with a .126 dimension and a .125 dimension.
- BRASS GUIDE (3):** Shows a cross-section with a .126 dimension and a .125 dimension.

Notes:

- ENGRAVE FIN. CHARACTER HT. .090.
- ENGRAVE 'PRIMARY'.
- ENGRAVE 'SECONDARY'.

QTY	DESCRIPTION
1	0-1 DRILL ROD Ø2-1/8 x 1-7/8
3	BRASS RND Ø2 x 5/16
3	0-1 DRILL ROD Ø3/8 x 1/2
1	BRASS RND Ø3/4 x 3/8
1	1018 RND Ø1/4 x 1-1/8
1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø3/4 x 3/4

QTY	DESCRIPTION
1	0-1 DRILL ROD Ø2-1/8 x 1-7/8
3	BRASS RND Ø2 x 5/16
3	0-1 DRILL ROD Ø3/8 x 1/2
1	BRASS RND Ø3/4 x 3/8
1	1018 RND Ø1/4 x 1-1/8
1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø3/4 x 3/4

QTY	DESCRIPTION
1	0-1 DRILL ROD Ø2-1/8 x 1-7/8
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1	BRASS RND Ø3/4 x 3/8
1	1018 RND Ø1/4 x 1-1/8
1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø3/4 x 3/4

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1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø3/4 x 3/4

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1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø3/4 x 3/4

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1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø3/4 x 3/4

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1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø3/4 x 3/4

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1	1018 RND Ø1-7/8 x 1-1/8
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1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø3/4 x 3/4

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1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø3/4 x 3/4

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1	1018 RND Ø1-7/8 x 1-1/8
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1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø1-7/8 x 1-1/8
1	1018 RND Ø3/4 x 3/4

QTY	DESCRIPTION
1	0-1 DRILL ROD Ø2-1/8 x 1-7/8
3	BRASS RND Ø2 x 5/16

[illegible][illegible]